DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-029851
Date Inspected: 17-Jul-2013

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: USA Hoist

OSM Arrival Time: 730
OSM Departure Time: 1600
Location: Crest Hill, IL.

CWI Name:	None present this day	**CWI Present:**	☐ Yes ☑ No
Inspected CWI report:	☑ Yes ☐ No ☐ N/A	**Rod Oven in Use:**	☑ Yes ☐ No ☐ N/A
Electrode to specification:	☑ Yes ☐ No ☐ N/A	**Weld Procedures Followed:**	☑ Yes ☐ No ☐ N/A
Qualified Welders:	☑ Yes ☐ No ☐ N/A	**Verified Joint Fit-up:**	☑ Yes ☐ No ☐ N/A
Approved Drawings:	☑ Yes ☐ No ☐ N/A	**Approved WPS:**	☑ Yes ☐ No ☐ N/A
		Delayed / Cancelled:	☐ Yes ☑ No ☐ N/A

Bridge No: 34-0006
Component: Tower Elevator Components

Summary of Items Observed:

This Quality Assurance Inspector (QAI) arrived at the USA Hoist production facility for the purpose of performing inspections of Tower Elevator items to the requirements CC0-085, Standard Specification and Special Provisions.

This QAI observed the welding of the tubesteel beams identified as attachment items #2(plate), #3(pipe), #4(rod), #1(tubesteel). The welding was performed by, Andres Luna #1233, utilizing the Kobe Steel 'Familiarc' E71T-1 . 045" diameter FCAW-G wire as per Welding Procedure Specification (WPS) identified as FCAW3210. The shielding gas used was mixture of 75% Argon and 25% CO2 with a flow rate of 36CFH. The welding appeared to meet the requirements of the contract documents.

The cutting and fit-up was observed by this QAI of the following shop components: mounting angle #4 to item #2 of Drawing# 916240-03 for incorporation into Right-Handed members (2 total) of Drawing# 916232-56 and Left-Handed members (2 total) of Drawing# 916232-57. The tack-welding was performed by the welder, Manola Luna #B, utilizing Kobe Steel brand 'Familiarc' E71T-1M .045" diameter FCAW-G electrode as per the Welding Procedure Specification identified as FCAW3210. The shielding gas used was a mix of 75% Argon and 25% CO2.

The fit-up and the welding was also observed by this QAI of the item #2(2" pipe-sleeve) to the item #1(tubesteel) per the Drawing #916240-03. The welding was performed by Manola Lunas #B utilizing Kobe Steel brand 'Familiarc' E71T-1M .045" diameter FCAW-G electrode as per the WPS identified as FCAW3210. The shielding gas used was a mix of 75% Argon 25% CO2 with a flow rate of 38CFH. The welding was completed of these members and appear to meet the requirements of the contract documents.

WELDING INSPECTION REPORT

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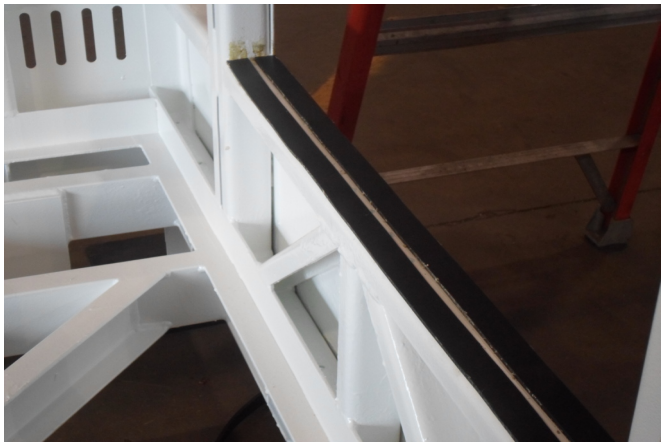
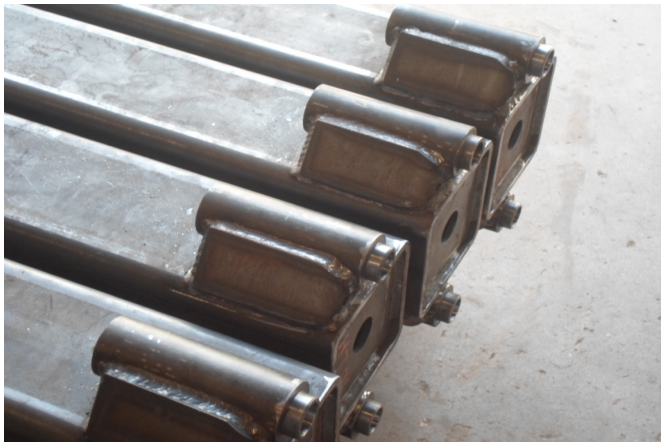
Other work witnessed by QAI this day was: 1) the press-fitting of alignment bushings into the counter-bored ends of Tower Elevator Masts (44 total to date) and 2) the fitting/bonding of rubber seal/cushions to to Elevator Cab between it's frame and window frame inserts.





Summary of Conversations:

This QAI spoke with Project Manager Tim Moran, inquiring as to the results of the powder-coating by Americana of the sample Elevator Landing angle which was re-galvanized by MW Galvanizing. Mr. Moran expressed that the powder-coating of the angle was reported by Americana as having an unacceptable, blistered surface finish.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Morris,Monty	Quality Assurance Inspector
Reviewed By:	Foerder,Mike	QA Reviewer